

Garant**GARANT Master Alu PickPocket solid carbide roughing end mill HPC, DLC, Ø e8 DC: 4mm****Order data**

Order number	202004 4
GTIN	4062406125882
Item class	11X

Description**Version:**

With the latest generation of DLC coating sp^2 .

For roughing and finishing.

Up to $2 \times D$ into solid material at very high feed rates and smooth cutting action.

Very high feed rates when plunging vertically.

Ramping capability up to 45° .

Advantage:

Optimised flute form, eccentric relief ground, generous chip spaces.

Tolerance nominal Ø: e8

No. of teeth Z: 3

Helix angle: 42°

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h6

Balance quality with shank: G 2.5 with HA

No. of teeth Z: 3

Flute length L_c : 8 mm

Overall length L: 57 mm

Shank Ø D_s : 6 mm

Corner rounding r_v : 0.1 mm

Feed f_z for slot milling in short-chipping aluminium: 0.05 mm

Technical description

Helix angle	42°
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Overall length L	57 mm
Feed f_z for side milling in short-chipping aluminium	0.06 mm
Cutting edge $\varnothing D_c$	4 mm
Feed f_z for slot milling in short-chipping aluminium	0.05 mm
Tolerance nominal $\varnothing$	e8
Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	3
Flute length L_c	8 mm
Shank	DIN 6535 HA to h6
Shank $\varnothing D_s$	6 mm
Balance quality with shank	G 2.5 with HA
Corner rounding r_v	0.1 mm
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
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Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	Suitable	550 m/min	N

Aluminium (short chipping)	suitable	500 m/min	N
Alu > 10% Si	suitable	450 m/min	N
PMMA acrylic	Suitable	200 m/min	N
PE-HD	Suitable	160 m/min	N
PA 66	Suitable	200 m/min	N
PEEK	Suitable	150 m/min	N
PF 31	Suitable	130 m/min	N
PVDF GF20	Suitable	180 m/min	N
POM GF25	Suitable	160 m/min	N
PA 66 GF30	Suitable	150 m/min	N
PEEK GF30	Suitable	130 m/min	N
PTFE CF25	Suitable	160 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	300 m/min	N
Cu	Suitable	160 m/min	N
CuZn	Suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable		

Services

Shank grinding Type HB

129100 HB